




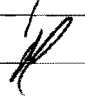






Work Order ID 69532

Wednesday, May 11, 2011 4:05:55 PM

Page 1

Item ID:	D2022-101	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Spacer					
Start Date:	5/11/2011	Start Qty: 60.00		Cust Item ID:		
Required Date:	5/16/2011	Req'd Qty: 60.00		Customer:		
Reference:						
Approvals:	Process Plan: 	Date: 11-05-12	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:		Stop
						
						

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
100		0.00				60	0		
									
Hardinge		0.00							
Hardinge CNC Lathe Small	Memo Note: .257" dia drill 1-Turn as per folio FA206 & dwg FOLIO REV: <u>N/A</u> DWG REV: <u>1</u> 2-Deburr as required								
110	QC2- Inspect parts off machine FAI/FAIB	0.00				60	0		
									
QC		0.00							
Quality Control									

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69532

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Wednesday, May 11, 2011 4:05:55 PM

Item ID: D2022-101

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacer

Start Date: 5/11/2011 Start Qty: 60.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 60.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC8- Inspect parts - second check

0.00



QC Memo

0.00

Quality Control

20 11-6-2

60

130 Identify as per dwg & Stock Location: 504

0.00



Packaging Memo

0.00

Packaging

11/6/11 60

140 QC21- Final Inspection - Work Order Release

0.00



QC Memo

0.00

Quality Control

11/6/11
ME
11-06-03

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, May 11, 2011 4:06:01 PM

Page 1

Work Order ID: 69532

Parent Item: D2022-101

Parent Item Name: Spacer




Start Date: 5/11/2011

Required Date: 5/16/2011

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP ☐ D02.03.07 ☐ Now made in house ☐ NG ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750  6061-T6 Round Bar .750"		Purchased	No			100	f	71.4030	0.03	1.8		5/16/12	

Location

Loc Qty

Loc Code

MAT013

71.403

112442

0.796

116406

0.617

117481

69.99

1.8 Rt

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

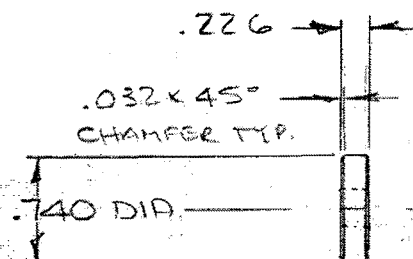
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 09537

RELEASED
170114 BW



D2022-101.
D2022-103

DRILL F (.257) DIA. IN -101-
DRILL P (.323) DIA IN -103

MAT'L: ALUMINUM 6061-T6 (QQ-A-225/B)



D2022

D2022-103		SPACER 5/16 ALUM. 6061-T6		QQ-A-250/B
D2022-101		SPACER 1/4 ALUM. 6061-T6		QQ-A-250/B

PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC/VENDOR
DART AERO ACCESSORIES INC				

REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.	DRILL CODE SHALL BE PER MAS 323	QTY REQUIRED	APPROVAL
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